Work Order II	108638
---------------	--------

\*108638\*

Page 1

October-25-13	1:13:25 PM				,, ,, ,, ,, ,							
Item ID: Revision ID:	D3176-3			Accept	*N	1900	040	100	)*	Setup Star	IV	S1*
Item Name:	Nut									Stop	*N	S2*
Start Date:	10/25/13	<b>Start Qty: 20.00</b>	*20*		(	Cust Item I	D:					•
Required Date:	: 11/08/13	Req'd Qty: 20.00	*20*		(	Customer:						
Reference:												
Approvals:	Process Pla	n:MLJ	Date: 13-10-2	Tooling:		D:	ate:		]	Run Star	I <i>Z</i> I	R1*
	QC:		Date:	<b>SPC (Y/N):</b>		D:	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hour	s	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3176	Rev	A										
100		Hardinge CNC LATHE S	SMALL	0.00	120		i		2-	2		
*100* Hardinge		Memo		0.00	40	13/11/	102			Ø		
Hardinge CNC Lath	ne Small	1-Turn as pe	r Folio FA286 & DWG D31	762-Deburr	9-89							-
												. t. 5. a. 7. 3.
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00								- -
*110*	·								20	Ø		
QC		Memo		0.00	SAS	,	,					
Quality Control					OAS (40 8-80	13/11/	/oL					
120				0.00								
*120*		CONVENTIONAL MILI	LING MACHINE		DAS	10.1	100		20	<u> </u>		
Mill Conv	na Machina	Memo	as ner dwg D31762. Dehur	0.00	9-83	13/11	1/02					

DQA: Date:															
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UP	PDATE	Wo	ork Order up	odate only   [	$\neg$	AEROSPACE.	
					DISPOSITION			<del></del>	ACAINST						
Work Orde	er:				DISPOSITION	_			AGAINST	DE	PARTMENT,	PROCESS		•	
					Rework	]		Skid-tube	Crosstube			Water Jet		Engineering	
Part N	lo				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality	
					Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other	
NCR N	lo				Suspected Unapproved	]		Large Fab	Composite			Supplier			
Root				Desc	ription of work order update		Initial	Acti	on		Sign &		T	·	
Cause	Date	e Step	Qty		or non-conformance	Cr	nief Eng	Descri	ption		Date	Verification		QC Inspector	
Design															
Doc/Data													-		
Equip/Tooling															
Handling/Pre															
Material													-		
Operator													1		
Offset/Setup						1									
Process						1							ŀ		
Supplier															
Training	_										·	:			
Transport Unapproved													ļ		
Onapproved	I		i	<u> </u>		ΕΛ	III T CA	TEGORY			<u> </u>	L	L		
Landir	ng Gear				General	10	OLI CA	IEGORI							
	Bendir	ıg			Bend	Г	] Folio/F	Program			Outside Dim	ensions [	$\neg$	Pressure/Forced	
Ì	_	Not Conce	ntric		BOM/Route	$\vdash$	Grain	10614111		_	Over/Under	<b>}-</b>		Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	are		_	Part Incorre	<b>⊢</b>	_	emperature/Cure	
Ì	Crimp/	Kink/Ripple	e/Wave		Burrs	$\vdash$	1	ion Incomplete/Un	gualified	$\vdash$	Part Lost/Mi	<b>⊢</b>	-	Veld	
	Cuffs				Contamination		1	tions Incomplete/U	-		Part Moved		_	Wrong Stock Pulled	
	Crushi	ng			Countersink		4	gned/off center			Positioned V	L Vrong		<b>.</b>	
	Heat T	reat			Cut Too Short		Mislabe				Power Loss/		$\Box$	Other	
	Inspec	tion Strip in	Tube		Drawing		Misrea	d			•	- [			
	Marks,	/Chatter			Drill Holes		Off-set								
	Turnin	g Sequence	<u>:</u>		Finish		Out of	Calibration							
	Wave/	Twist in Tu	he		Fit/Function		Out of	Saguence							

		-	-			-		_	•••		_	-	-		-						_		-	
١	V	Ì	7	0	) ]	r	•	k		(	)r	.(	d	eı	•	II	)	1	0	8	6	3		

## \*108638\*

Page 2

October-25-13	1:13:25 PM								·····			
Item ID: Revision ID:	D3176-3		<i>k</i>	Accept	*	<b>V9</b> 00	040	100	<b>)*</b> s	etup Star Stop		S1*
Item Name: Start Date: Required Date: Reference:	Nut 10/25/13 11/08/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item 1 Customer:	ID:				IN.	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N	N):		ate:		R	tun Star Stop	17	R1* R2*
Sequence ID/ Work Center II  130 *130* QC Quality Control	D	Operation Description QC2- Inspect parts off ma	achine FAI/FAIB	Set Up Run H 0.00		Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC8- Inspect parts - seco	nd check	0.00	À.e	, 13	11/03		20	φ_		0A5 08 28
*150 *150* Packaging Packaging		Identify as per dwg & Sto	ck Location: STO3	0.00					_ <i>2</i> 0}	DAS 28 9-89	13-	11-4

DQA:			Date:			_							
			-			WORK ORDER NON	-CO	ONFO	RMANCE / U	PDATE			A E ROS PACE
QA Closed:			Date:		-				<u>-</u>		Vork Order up	odate only	AEROSPACE
Mark Orda						DISPOSITION				AGAINST D	<b>EPARTMENT</b>	/PROCESS	
Work Orde	T : -	- · · - · · -				Damark	1		دارنم امران	C	7	14/040" Lot	
Part N	^					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	- Dro	Water Jet	Engineering
raitiv	٠.					Use-as-is			noforming	Finishing	_	d. Eng. Coor. re/Packaging	Quality Other
NCR N	lo					Suspected Unapproved	Large Fab Composite Supplier					<b>—</b>	
	٠					Suspected Onapproved	Large rab composite Supplier						_
Root		<del>.</del>			Desc	ription of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date Verification		QC Inspector
Design													
Doc/Data													
Equip/Tooling							1						
Handling/Pre													
Material													
Operator													
Offset/Setup	_												
Process	_												
Supplier	_												
Training													
Transport													
Unapproved		-					<u> </u>						
<u></u>			<del> </del>				FA	ULT CAT	regory				
Landin						General		1		_	_	_	_
	_	Bending			_	Bend	<u> </u>	1	rogram	-	Outside Dim	<b>⊢</b>	Pressure/Forced
		Centre No	ot Concer	itric	<u> </u>	BOM/Route		Grain		1	Over/Under	<b>⊢</b>	Set-up
-		Cracks	1 /5: 1	Broken/Damage/Defec				Hardwa			Part Incorre	<u></u>	Temperature/Cure
-	-	Crimp/Kink/Ripple/Wave Burrs			1	ļ	1	ion Incomplete/Ur	· -	Part Lost/Mi	_	Weld	
		Cuffs	H			4	_	-	ions Incomplete/l	Jnclear	Part Moved	<u> </u>	Wrong Stock Pulled
}		Crushing	.+		-				ned/off center	<u> </u>	Positioned V		ا م
}	$\dashv$	Heat Treat Cut Too Short Inspection Strip in Tube Drawing					Mislabeled Power Loss/Surge			Surge	Other		
-	$\dashv$			une	$\vdash$	Drill Holes	Misread						
1	<b>├</b> ┤ , <b>├</b> ┤					Finish	$\vdash$	Off-set	Calibration		<del></del>	· · · · · · · · · · · · · · · · · · ·	
}	_	_	-		-	Fit/Function	$\vdash$	1					
	Wave/Twist in Tube   Fit/Function						<u>L</u>	Jour or s	Sequence				

Work Ord October-25-13				*108638*										
Item ID: Revision ID: Item Name:	D3176-3 Nut			Accept	*N900040	1100*	: Setup	Start Stop	*NS					
Start Date: Required Date Reference:	10/25/13 : 11/08/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:									
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NF					
Sequence ID/ Work Center I	D	Operation Description OC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID Tool #		accept Re Oty Q	-	-	Insp. Stamp				

0.00

Memo

\*160\*

Quality Control

JAM 13/11/07. WF 13/11-05

DQA:			Date: .		WORK ORDER NON-CONFORMANCE / UPDATE								DART
QA Closed:			Date:			WORK ORDER NON-		JINFOI	NIVIAINCE / OF		Nork Order u	pdate only	AEROSPACE
Work Orde	ar.					DISPOSITION				AGAINST [	DEPARTMENT	/PROCESS	
Part N						Rework Scrap			Skid-tube Machining	Crosstube Small Fab	_	Water Jet od. Eng. Coor.	Engineering Quality
NCR N	No				<del></del>	Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Desci	ription of work order update	1	nitial	Acti	ion	Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport													
Unapproved		J											
							FAI	ULT CAT	regory				
Landii	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Un ions Incomplete/U ned/off center eled	·	Outside Din Over/Under Part Incorre Part Lost/M Part Moved Positioned Power Loss	r tolerance ect lissing Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence Wave/Twist in Tube				Finish Fit/Function	$\vdash$	4	Calibration Sequence					
	ι Ιννα	• ~ J   VV	JULI IUL	,_	- 1	, , , , , , , , , , , , , , , , , , ,	1	TOUL OF 3	JEVUELLE				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

## **Picklist Print**

October-25-13 1:13:29 PM

Page 1

Work Order ID: 108638

\*108638\*

Parent Item:

D3176-3

\*D3176-3\*

Parent Item Name: Nut

Start Date: 10/25/13

Required Date: 11/08/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP Rev:B Removed -1

05-11-29

JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	96.8680	0.05	2	۵۸۵.		,02
*M303R1 (	<b>೧</b> ೧೧*								**		40	13/	1/22

303 Round Bar 1.00

Loc Code Location Loc Qty MAT028 96.86801579 121070 1.5789E-05 2.0 **~D** m126618 96.868

DQA:			Date:										
			_			WORK ORDER NON-	-CC	ONFO	RMANCE / UI			_	AEROSPACE
QA Closed:			Date:							V	Vork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
						Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	10					Suspected Unapproved			Large Fab	Composite	7	Supplier	
												<del></del>	
Root					Desci	ription of work order update	1	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design	_												
Doc/Data	_	l											
Equip/Tooling							l						
Handling/Pre	_												
Material	_												
Operator	_												:
Offset/Setup	_												
Process	_												
Supplier	$\dashv$												
Training	_												
Transport	_												
Unapproved									FCORY				<u> </u>
Landir	og Goo	<u> </u>				General	FA	ULI CAI	TEGORY				
Carion		i nding			Г	Bend		leolio/B	rogram	Г	Outside Dim		
}	—		t Concer	ntric	-	BOM/Route	$\vdash$	Grain	rogram	-	Over/Under	<b> </b>	Pressure/Forced
ŀ	_	icks	Concer	itiit		Broken/Damage/Defect		Hardwa	ro	-	Part Incorred	<u> </u>	Set-up Temperature/Cure
}			k/Ripple	/Wave		Burrs		1	ion Incomplete/Ur	auglified	Part Lost/Mi	<b></b>	Weld
}	Crimp/Kink/Ripple/Wave			Contamination		1 '	ions Incomplete/U	· –	Part Moved	23111g	Wrong Stock Pulled		
ļ	Cuffs Crushing					Countersink		4	ned/off center	-	Positioned V	L Vrong	
1		at Trea	t			Cut Too Short	$\vdash$	Mislabe		<u> </u>	Power Loss/		Other
}	Inspection Strip in Tube				Drawing	-	Misread		L			Totalei	
	Marks/Chatter					Drill Holes		Off-set	-				
			equence			Finish		4	Calibration				
	Wave/Twist in Tube					Fit/Function	Out of Sequence						

DART AEROSPACE LTD	Work Order: 10 8 6 3 /	?
Description: Nut	Part Number: D3176-3	
Inspection Dwg: D3176 Rev: A	Page 1 of	1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.990	+/-0.010	.987	/		A EVY	140-12
0.130	+/-0.010	. 130			i.	1,
R0.005-0.015	+/-0.000	.015			Rad G	
0.594	+/-0.010	. 596			VERN	PC10-12
0.745	+0.005/-0.000	.746			, -	l-
5/8-UNF18-3B	N/A	N/A				
		3. Jt 911 P.A. VQ181		· · · · · · · · · · · · · · · · · · ·		
		**************************************				

~^^ A C					
Measured by: (40	Audited by:	B.0	DAS	Prototype Approval:	N/A
Date: 13/11/02	Date:	13/11/0	ع <b>08</b> کی	Date:	N/A

Rev	Date	Change	Revised₁by	Approved
Α	03.11.12	New Issue	KJ/RF	- 4

